

Date: Thursday, 1/25/2007 10:21:06 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CROSSBOLT SPACER		
Job Number	: 30448			Part Number	: D2743		
Estimate Number	: 10329			Drawing Number	: D2743 REV B		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 1/25/2007	S.O. No.	: N/A	Drawing Revision	: B		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 2/20/2007		
Previous Run	: 29342			Qty:	200		
Written By	: <u>H. W.</u>			Um:	Each		
Checked & Approved By	: <u>H. J. 07.01.25</u>						
Comment	: Est E 05.04.13 Reformat; removed tumble and deburr step KJJ						
	LM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0625W065	6061-T6 Tube .625 x.065W 
		
	Comment: Qty.: 0.2800 f(s)/Unit Total : 56.0070 f(s) Material: 6061-T6 (WW-T-700/6) Ø0.625 " x 0.065" wall (M6061T6T0625W.065) Batch: <u>102450</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
		
	Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA202 and Dwg D2743	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>RG 07-02-01</u> 2.3
4.0	QC8	SECOND CHECK 
		
	Comment: SECOND CHECK	<u>RG 07-02-01</u> 2.3
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG	<u>RG 07-02-05</u> 213

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/02/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE



(213)

1/27/02/06

Job Completion



1/27/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30448
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

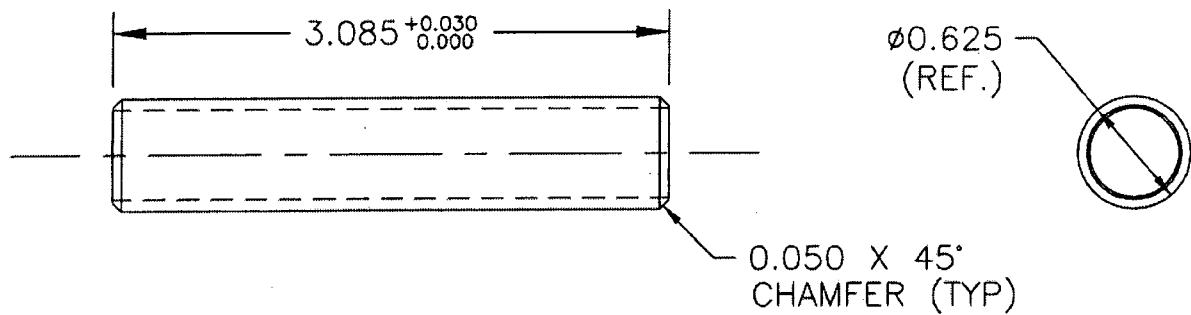
X First Article Prototype

Measured by:	<i>BC</i>	Audited by:	<i>EP</i>	Prototype Approval:	N/A
Date:	07/02/02	Date:	07/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.11.20	Tolerance +/-0.010 x 45° was 0.48 x 45°	KJ/JLM	

DART

DESIGN <i>#</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>#</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.12.16 DS

MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL COPY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
POTENTIAL TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *304448*